

slp Oct 20

Work Order ID 74181

Monday, September 26, 2011 3:24:12 PM



Item ID: K10112

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Skidtube 206

Start Date: 9/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/19/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
K10112	B								
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP K10112								
	FOR D206-642-112 CHG006								
	-114 CHG001								
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

~~D206-642-112~~

~~CHG006~~

CHG002

CHG002

S u l c o l e d

HJ for MLJ 11-10-4

SP 11-10-4

S u l c o l e d

(5)

Work Order ID 74181

Monday, September 26, 2011 3:24:12 PM

Page 2

Item ID: K10112

Accept

Revision ID:

Item Name: Saddle, Skidtube 206

Start Date: 9/26/2011 Start Qty: 5.00

Required Date: 10/19/2011 Req'd Qty: 5.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP k10112

Location:

PPP rev: DRAFT

PPP 75283 74426
74429 74424
74427

SP11-10-20

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/10/2011
MF
11-10-20

Picklist Print

Monday, September 26, 2011 3:24:09 PM

Page 1

Work Order ID: 74181

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206



Start Date: 9/26/2011

Required Date: 10/19/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: E000.06.14 Changed GHW part # (mpp 2063) EC IPP REV:F
11.09.23 PER REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-41A

Purchased

No

110

Each

2,295.000

8

40



Bolt

Location

Loc Qty

Loc Code

ST354

295

116191

195

118706

100

st510

2000

119042

2000

AN4-6A

Purchased

No

110

Each

6,216.000

12

60



Bolt

Location

Loc Qty

Loc Code

ST356

1200

117872

200

118422

300

118628

400

118838

300

ST358

16

117514

16

ST516

5000

119017

5000

40X

SP 11-10-4

60X

Picklist Print

Monday, September 26, 2011 3:24:09 PM

Page 2

Work Order ID: 74181

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/26/2011

Required Date: 10/19/2011

Start Qty: 5.00

Required Qty: 5.00

AN4C5A

Purchased

No

110

Each

583.0000

BOLT

Location

Loc Qty

Loc Code

FP-B

94

112243

94

ST345

389

112243

389

ST356

100

119017

100

Purchased

No

110

Each

3,197.000

AN5-7A

Bolt

Location

Loc Qty

Loc Code

ST337

197

117313

14

117441

132

118422

1

118706

50

ST516

3000

119017

3000

Purchased

No

110

Each

643.0000

AN6-44A

Bolt

Location

Loc Qty

Loc Code

ST344

43

110372

43

st510

600

119036

600

Picklist Print

Page 3

Monday, September 26, 2011 3:24:09 PM

Work Order ID: 74181

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/26/2011

Required Date: 10/19/2011

Start Qty: 5.00

Required Qty: 5.00

D206-651-041

CHC701

Manufactured No

110 Each

19.0000

206A/B GHW

Location

Loc Qty

Loc Code

FG120

19

19

110 Each

96.0000

D2652

Manufactured No

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST

52

53741

0

72120

52

110 Each

12.0000

D2661=2

Manufactured No

Saddle, RH Fwd Aft Out 206

Location

Loc Qty

Loc Code

Mezz

1

10015

1

10016

1

10475

2

10476

1

7159

4

9913

1

9915

2

Monday, September 26, 2011 3:24:09 PM

Shop Packet Print

Page 3

Picklist Print

Monday, September 26, 2011 3:24:09 PM

Page 4

Work Order ID: 74181

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/26/2011

Required Date: 10/19/2011

Start Qty: 5.00

Required Qty: 5.00

D2662-2

Manufactured No

110

Each

17.0000

10



Saddle, RH In 206



2

10

3738464x

8P11-10-4

B64557

60x

Location

Loc Qty

Loc Code

ST435

6

10022

1

11028

4

6946

2

7374

3

8430

1

8767

1

9042

3

9043

2

74482 9x

74483 1x 11/1/20

D2712

Manufactured No

110

Each

1,461.000

10

50



Set Screw



10

50

8P 11-10-4

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1411

71160

111

72231

300

73837

1000

50x

Monday, September 26, 2011 3:24:10 PM

Shop Packet Print

Page 4

Picklist Print

Monday, September 26, 2011 3:24:10 PM

Page 5

Work Order ID: 74181

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/26/2011

Required Date: 10/19/2011

Start Qty: 5.00

Required Qty: 5.00

D2884
Saddle Spacer

Manufactured No

110 Each

264.0000

2 10

Location

Loc Qty

Loc Code

FG 10
29453 10
ST025 254
52302 22
73306 24
73823 208

2X
8X

D2885
Saddle Spacer

Manufactured No

110 Each

50.0000

2 10

Location

Loc Qty

Loc Code

FG 10
29199 10
ST025 40
52303 40

10X

D3413
Ring

Manufactured No

110 Each

59.0000

1 5

Location

Loc Qty

Loc Code

ST420 19
66387 1
70773 18
ST467 40
72137 20
73298 20

5X

8P 11-10-4

Monday, September 26, 2011 3:24:10 PM

Shop Packet Print

Page 5

Picklist Print

Monday, September 26, 2011 3:24:10 PM

Page 6

Work Order ID: 74181

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/26/2011

Required Date: 10/19/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

110

Each

8,431.000

8 40

Nut

Location

Loc Qty

Loc Code

ST300

2431

117441

16

117601

260

117885

155

118451

1000

118927

1000

ST516

6000

119017

6000

MS21042L4

Purchased

No

110

Each

9,993.000

12 60

Nut

Location

Loc Qty

Loc Code

ST300

3993

117441

51

117601

637

117885

305

118451

2000

118927

1000

ST516

6000

119017

6000

Monday, September 26, 2011 3:24:10 PM

Shop Packet Print

Page 6

Picklist Print

Monday, September 26, 2011 3:24:10 PM

Page 7

Work Order ID: 74181

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/26/2011

Required Date: 10/19/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L6

Purchased

No

110

Each

944.0000

2

10



Nut

Location

Loc Qty

Loc Code

ST300

944

117677

200

118384

46

118927

98

118968

600

OK

NAST149C0463R

Purchased

No

110

Each

490.0000

1

5



Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

489

117735

489

5x

NAST149D0363J

Purchased

No

110

Each

4,404.0000

8

40



Washer

Location

Loc Qty

Loc Code

ST298

4404

117601

274

118077

1130

118612

1000

118968

2000

40x

Monday, September 26, 2011 3:24:10 PM

Shop Packet Print

Page 7

Picklist Print

Monday, September 26, 2011 3:24:10 PM

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Parent Item Name: Saddle, Skidtube 206

Start Date: 9/26/2011

Required Date: 10/19/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

110

Each

3,305.000

24

120



Washer

Location

Loc Qty

Loc Code

ST297

200

118853

200

ST298

2105

116025

16

116805

0

117291

1

117460

2

117591

108

118179

43

118384

1031

118612

904

ST302

1000

119042

1000

NAS1149D0563J

Purchased

No

110

Each

4,577.000

8

40



Washer

Location

Loc Qty

Loc Code

ST298

4577

118206

3577

118614

1000

NAS1149D0663J

Purchased

No

110

Each

944.0000

4

20



Washer

Location

Loc Qty

Loc Code

ST298

944

115996

5

117977

439

118614

500

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-112
BELL 206 A/B	D206-642-114

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10112	D206-642-112	D206-642-114
D206-651-041	1	1	1
D2652	16	16	16
D3413-1	1	1	1
D2661-2	2	2	2
D2662-2	2	2	2
D2712	10	10	10
D2884	2	2	2
D2885	2	2	2
AN3-41A	8	8	8
AN4C5A	1	1	1
AN4-6A	12	12	12
AN5-7A	8	8	8
AN6-44A	2	2	2
NAS1149D0363J	8	8	8
NAS1149D0463J	24	24	24
NAS1149D0563J	8	8	8
NAS1149D0663J	4	4	4
MS21042-3 (OR L3)	8	8	8
MS21042-4 (OR L4)	12	12	12
MS21042-6(OR L6)	2	2	2
NAS1149C0463R	1	1	1

RELEASED
2011-09-23

B	ADD APPLICABILITY TO D206-642-114	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	K10112	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE KIT	NTS
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